

Work Order ID 148967

July 12, 2016 11:52:01 AM

U/R

148967

Ship July 15 For Bell

Page 1

Item ID: D412-698-023 Accept *N900040100* Setup Start *NS1*

Revision ID: URF.16-531 Stop *NS2*

Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 7/12/2016 Start Qty: 2.00 *2*

Required Date: 7/15/2016 Req'd Qty: 2.00 *2*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: SH Date: 7/12/16 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN D412-698	Rev E U/R	<u>OK</u> <u>9/14/12</u> <u>JUL 13 2016</u>	DAS 6 9-89					DAS 21 9-89	<u>16-07-13</u> <u>(2)</u>
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-698-023		CHG002						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

JUL 14 2016

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Item ID: D412-698-023 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-531 Stop ***NS2***
Item Name: Automatic Door Opener (fits LH or RH)
Start Date: 7/12/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/15/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023 Location:FG022								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

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DAS
21
9-89
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21
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JUL 14 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 148967

148967

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-11		Manufactured	No			120	Each	12.0000	1	2			
----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3552-11

Door Prop

Location	Loc Qty	Loc Code
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FG	4	
128491	2	
80345	2	
ST363	8	
145244	8	

DAS
27
9-89

DAS
6
9-89

D3594-043		Manufactured	No			120	Each	9.0000	1	2			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3594-043

Floor Doubler Assembly, LH

Location	Loc Qty	Loc Code
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Quarantine	3	
147748	6	
ST504	6	
130499	6	

DAS
27
9-89

DAS
6
9-89

D3594-044		Manufactured	No			120	Each	13.0000	1	2			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3594-044

Floor Doubler Assembly, RH

Location	Loc Qty	Loc Code
----------	---------	----------

Quarantine	3	
147749	10	
ST504	10	
130500	10	

DAS
27
9-89

DAS
6
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Work Order ID: 148967

148967

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 2.00

Required Qty: 2.00

D3594-5

Manufactured No

120 Each

27.0000

1 2

D3594-5

Doubler

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST044

27

145406

27

D3622-1

Manufactured No

120 Each

20.0000

2 4

D3622-1

Ball Stud

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST046

20

144629

20

MS20426AD4-4

Purchased No

120 Each

4,355.000

2 4

MS20426AD4-4

Rivet

**

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

1936

125445

1936

ST312

2419

m132536

2419

MS21073L5

Purchased No

120 Each

56.0000

1 2

MS21073L5

Anchor Nut

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST298

56

m132680

6

m135058

50

DAS

27

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Shop Packet Print

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Work Order ID: 148967

148967

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0516J

Purchased

No

120

Each

225.0000

2

4

NAS1149D0516.J

Washer

Location

Loc Qty

Loc Code

ST264

225

M129706

25

M134943

200

DAS
27
9-89

DAS
6
9-89

DAS
26
9-89

JUL 13 2016

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: **E**

Date: 08.05.01